

Date: Friday, 07/07/2006 8:59:10 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER KIT
Job Number	: 27583		
Estimate Number	: 11799		
P.O. Number	: N/A	Part Number	: D25251
This Issue	: 07/07/2006 S.O. No. : N/A	Drawing Number	: D2525 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 15/06/2006 Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 30/06/2006
Checked & Approved By	: <u>N</u>	Qty:	20 Um: Each
Comment	: Est. B99.11.10 Re-format added Acid etch stepEC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0750	6061-T6 Round Bar .750"
	Comment: Qty.: 0.0620 f(s)/Unit Total : 1.2400 f(s) 6061-T6 Round Bar .750" <u>M 100 157</u> <u>06/07/11</u>	
2.0	LATHE CONV.	CONVENTIONAL LATHE
	Comment: CONVENTIONAL LATHE <u>06/07/11</u> <u>20</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>06/07/11</u> <u>20</u>	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK <u>SG 06/07/11</u> <u>20</u>	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <u>SAP 06/07/11</u> <u>20</u>	
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP <u>06/07/11</u> <u>20</u>	

Date: Friday, 07/07/2006 8:59:10 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER KIT

Job Number: 27583

Part Number: D25251

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST47

AL 06/07/12

(20)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/07/13

(20)

Job Completion



W 06-07-13

Date: Thursday, 6/15/2006 1:50:29 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER KIT
Job Number	: 27583		
Estimate Number	: 11799		
P.O. Number	:	Part Number	: D25251
This Issue	: 6/15/2006 S.O. No. :	Drawing Number	: D2525 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	:	Material	:
Written By	: <u>HA 06.06.15</u>	Due Date	: 6/30/2006 Qty: 20 Um: Each
Checked & Approved By	:		
Comment	: Est. B90.11.10 Re-format added Acid etch stepEC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O:

Make as per Dwg D2525

Material release note required

Material: 6061-T6, Ø.750"

(.062 Feet)

Batch:

2.0	D2525TP	Spacer Kit
-----	---------	------------



Conventional Lathe.



Comment: Qty: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Spacer Kit

3.0	PACKAGING 1 PC2	PACKAGING RESOURCE #1
-----	-----------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QCB	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:50:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER KIT

Job Number: 27583

Part Number: D25251

Job Number:



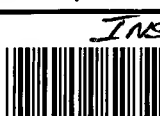
Seq. #:

Machine Or Operation:

Description :

6.0
QC3

~~QC3~~



Inspect Chemical
Conversion

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 06/07/13

NOTE: Date & initial all entries

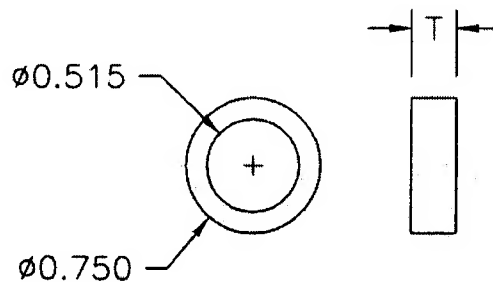
QA: N/C Closed: _____ Date: _____



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RF	DRAWING NO. D2525	REV. B SHEET 1 OF 1
DATE 99.09.30		TITLE SPACER KIT	SCALE 1:1
A	95.12.22	NEW ISSUE	
B	99.09.30	REVISED MATERIAL	

RELEASED
99.10.12 KE

PART NUMBER	THICKNESS T	QTY
D2525-1	0.750	1
D2525-3	0.250	1
D2525-5	0.125	4
D2525-7	0.063	0
D2525-9	0.032	0



MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)
OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

SHOP COPY
RETURN TO
DRAWING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27583

